

Customer	:	CU-DAR001 Dart Helicopters Services	Drawing Name	:	WEARPAD
Job Number	:	31695			
Estimate Number	:	10313			
P.O. Number	:	N/A	Part Number	:	D26483
This Issue	:	4/5/2007	S.O. No.	:	N/A
Prsht Rev.	:	NC	Drawing Number	:	D2648 REV D
First Issue	:	N/A	Project Number	:	N/A
Previous Run	:	30648	Type	:	SMALL /MED FAB
Written By	:	<u>[Signature]</u>	Drawing Revision	:	D
Checked & Approved By	:	<u>[Signature]</u>	Material	:	N/A
Comment	:	Est: E 02.08.18 Re-format; Incorporated D2648-1 KJ/RF	Due Date	:	5/5/2007
		Est Rev:F Now on Waterjet 06-08-14 JLM			

Qty: 200 Um: Each

**Job Number:**

Seq. #:	Machine Or Operation:	Description :
1.0	M1010S16GA	1010/1025/A21/6aA SHEET

Comment: Qty.: 0.0788 sf(s)/Unit Total: 15.7500 sf(s)  
1010/1025/A21/6aA SHEET  
(M1010S16GA)  
Batch: M104421

SAN 07/06/07 200

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET  
1-Cut as per Dwg D2648  
\*\*\*\*\*CUT WITH FILE D2648-1\*\*\*\*\*  
Dwg Rev: D  
Prog Rev: D

2-Deburr if necessary

SAN 07/06/07 200

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

SAN 07/06/07 200

4.0 QC8 SECOND CHECK

**Comment:** SECOND CHECK

82 07/06/07 / 20

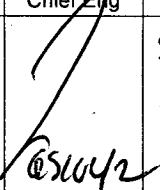
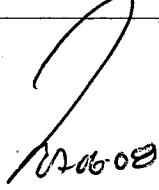
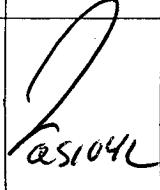

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1  
Deburr if necessary

07-06-11 200  
07/06/12 200

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/06/22  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/06/07	2.0	One Part moved when water jet was cutting		Setup and destroy / replace	SAN 07/06/07			

NOTE: Date & initial all entries

Date: Thursday, 4/5/2007 11:59:16 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 31695

Part Number: D26483

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1-Form as per Dwg D2648 on CNC brake using Jigs DT 8261 and DT 8326.

2-Identify as D2648-3

SB 07/06/12 (200)

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description Batch

A/R560Hardcoat

M104368

1-Weld as per Dwg D2648 using Jig DT 8210

2-Remove any weld that penetrated through Wearpad if necessary

Weld as per attached Engineering Approved custom

FC 07/06/14 (200)

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

12/07/06/19 (200)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

12/07/06/19 (200)

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M 10/601

FL/M-1 0706-21

(200)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 07/06/21 (200)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP-17.

FL 07/06/21 (200)

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

12/07/06/22

Job Completion



12/07.06.22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

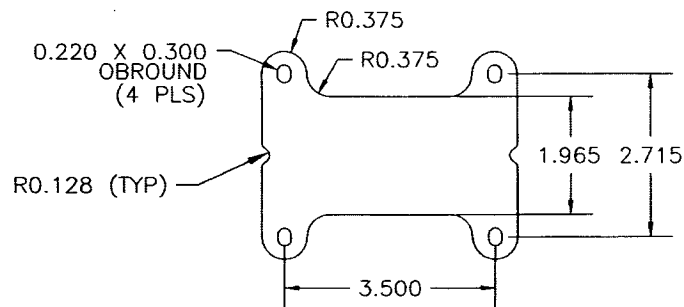
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

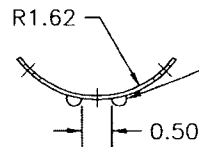
NOTE: Date & initial all entries



# D2648-1 FLAT PATTERN

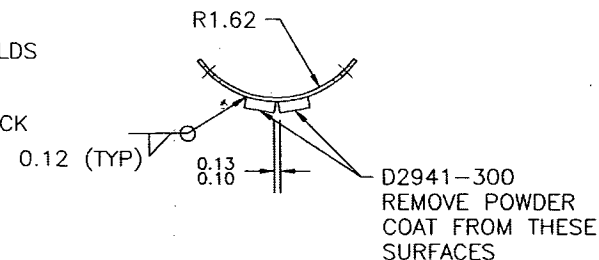


## SECTION A-A

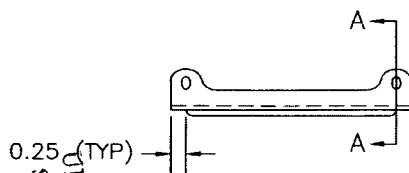


7560 HARDCOAT WELDS  
TO WITHIN 0.25 OF  
WEARPAD ENDS  
0.063 TO 0.125 THICK

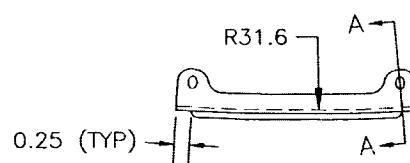
## SECTION B-B



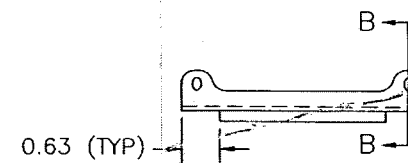
# D2648-3 LONGITUDINAL BEND (MADE FROM D2648-1)



# D2648-5 LONGITUDINAL BEND (MADE FROM D2648-1)



# D2648-7 LONGITUDINAL BEND (MADE FROM D2648-1)



RELEASED  
99.12.20 b5



NO. 31695  
WORK ORDER  
SUBJECT TO ASSIGNMENT  
WITHOUT NOTICE  
BROKEN ALL SHARP CORNERS 0.063 MAX  
MATERIAL: 16 GAUGE AISI 1010-1025 OR ASTM A36/A366 STEEL (0.063 THICK)  
FINISH: POWDER COAT GREY (REF. 4.3.5.5) PER DART QSI 005  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
ALL DIMENSIONS ARE IN INCHES

D	99.11.17	ADDED D2648-7
C	97.06.26	R31.6 WAS R19.6
B	97.05.30	ENLARGE OBOUND, 0.375 WAS 0.250
A	97.03.25	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC. BELLINGHAM, WA
CHECKED	APPROVED	DRAWING NO. D2648
DATE	99.11.17	TITLE WEARPAD
		REV. D SHEET 1 OF 1 SCALE 1:2

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